

Scrap

Work Order ID 50662

July 21, 2009 6:47:10 AM



Page 1

Item ID: D3755-041

Accept



Setup Start



Revision ID: B

Stop



Item Name: Seat Cushion

Start Date: 7/23/09 Start Qty: 6.00

Required Date: 8/07/09 Req'd Qty: 6.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3755

Rev B

100

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O:

101006

Manufacture D3753-1 as per Dwg D3753

Material: Airflex fire-resistant aircraft cushioning, grade 30-40

layers to be laminated with silaprene DC12906 spray grade HPL contact adhesive

Possible Supplier: Chestnut Ridgefoam

Material release note is required

CZ 09/08/12

6

110

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

Ensure Material Release Note is attached

9/8/12

DS

SCRAP

Work Order ID 50662

July 21, 2009 6:47:10 AM



Page 2

Item ID: D3755-041	Accept		Setup Start	
Revision ID: B			Stop	
Item Name: Seat Cushion				
Start Date: 7/23/09	Start Qty: 6.00		Cust Item ID:	
Required Date: 8/07/09	Req'd Qty: 6.00		Customer:	
Reference:				

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run Start	
	QC:	Date:	SPC (Y/N):	Date:	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							
QC	Memo	0.00							

Quality Control

130

Purchasing
Purchasing

PURCHASING

Memo

Issue P/O: 10229
 Upholster as per Dwg D3755
 Supplier: Lefebvre uphol
 Ship: -Qty 1 D3753-1 seat cushion
 -Qty 2 D3800-1-200-060 Loop strip
 -Qty 1 D3800-1-100-300, Loop strip
 -Qty 1 D3800-3-100-300, Loop strip
 Material release note is required

CANCEL

44360

SCRAP

CY 09/08/19 6

u 07.11.20

50541

① 44830

Work Order ID 50662

July 21, 2009 6:47:10 AM



Page 3

Item ID: D3755-041

Accept



Setup Start



Revision ID: B

Stop



Item Name: Seat Cushion

Start Date: 7/23/09

Start Qty: 6.00



Cust Item ID:

Required Date: 8/07/09

Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

SCRAP16 Non
11.02.06

Picklist Print

July 21, 2009 6:47:10 AM

Page 1

Work Order ID: 50662

Parent Item: D3755-041RevB

Parent Item Name: Seat Cushion

Comments:

Start Date: 7/23/09

Required Date: 8/07/09

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3800-1-200RevB		Manufactured	No			130	f	9.0000	3.3158			
Hook and Loop Strip (2" Soft)												

Measure @ 6" long
S 9/16/10

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	9	
4356	9	

B44360 S0

1- Cut to length as per dwg

D3800-3-100RevB Manufactured No



Hook and Loop Strip (1" Hard)

Measure @ 30" long
S 9/16/10

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	40.24	
43560	0.13	
44831	40.11	

1 30"

44831

Sx 30" S0541 S4

1- Cut to length as per dwg

D3800-1-100RevB Manufactured No



Hook and Loop Strip (1" Soft)

Measure @ 30" long
S 9/16/10

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	40.24	
43558	0.13	
44830	40.11	

1x 30"

44830

5" S0541 S0
9/18/10

1- Cut to length as per dwg

Picklist Print

Page 2

July 21, 2009 6:47:10 AM

Work Order ID: 50662



Parent Item: D3755-041RevB



Parent Item Name: Seat Cushion



Start Date: 7/23/09

Required Date: 8/07/09

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3753-1P 		Manufactured	No			130	Each	0.0000	6.0000			
Seat Foam D3755-041P 		Manufactured	No			140	Each	0.0000	6.0000			
Seat Cushion												

50662 

~~50662~~ 

SV

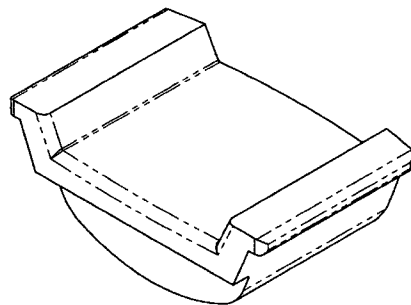
SCRAP

July 21, 2009 6:47:10 AM

Shop Packet Print

Page 2

WFO 50612



D3753-1 SEAT FOAM

UNDER REVIEW

09/02/09 CP
1999 07-01

OK UP 09/04/06

RELEASED
08/11/05

NOTES:

- 1) MATERIAL: AIRFLEX FIRE-RESISTANT AIRCRAFT CUSHIONING
GRADE 40-50 (COLOR: LIGHT YELLOW) LAMINATED TO GRADE 55-65 (COLOR: TAN)
WITH SILAPRENE DC12906 SPRAY GRADE HPL CONTACT ADHESIVE
SUPPLIER: CHESTNUT RIDGE FOAM INC., P/N 503330-99
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3753-1" USING PERMANENT MARKER
- 7) WEIGHT: 2.5 lbs
- 8) FOAM SHAPE TO CONFORM WITH TEMPLATE DT9027

C	CHG SHAPE TO MATCH CHESTNUT SAMPLE: 5.69 WAS 5.85 (B8-2), 4.00 WAS 4.25 (B3-2), 1.25 WAS 1.00 (B3-2)	CP	08.10.08
B	FOAM SHORTER TO AVOID CYCLIC, 12.25 WAS 16.75 (C7-2), 5.85 WAS 6.88 (B8-2), FRONT PROFILE CHANGED (B3-2)	CP	08.09.09
A	NEW ISSUE	CP	08.04.25
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CP		
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.	BE	D3753	SHEET 1 OF 2
APPROVED	CP	TITLE	SCALE
DE APPR.	PH	SEAT FOAM	NTS
DATE	08.10.08	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8

7

6

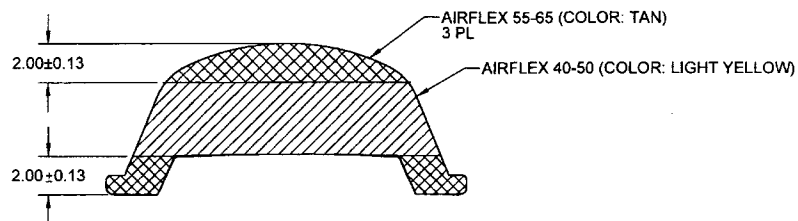
5

4

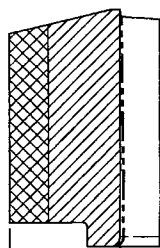
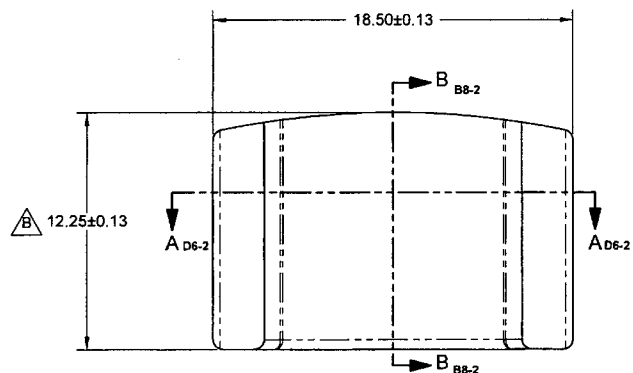
3

2

1

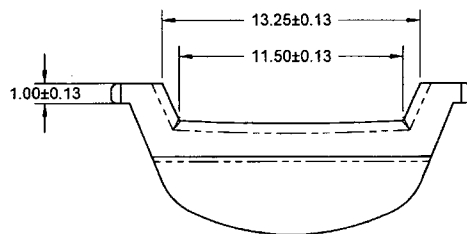


SECTION A-A c8-2



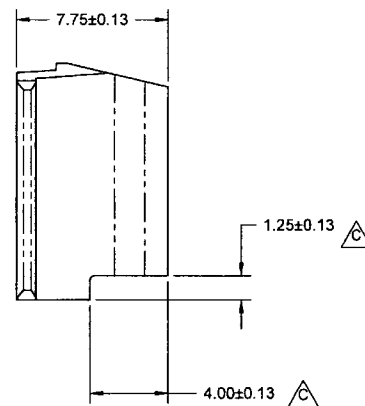
5.69±0.13

SECTION B-B c8-2



1.00±0.13

D3753-1 SEAT FOAM



7.75±0.13

1.25±0.13

4.00±0.13

UNDER REVIEW

08/02/08

OK

09.04.08

RELEASED

08/11/05

DESIGN	GP	DART AEROSPACE LTD	
DRAWN	GP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.	PH	D3753	SHEET 2 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	SEAT FOAM	NTS
DATE	08.10.08	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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PARTS LIST

ITEM	QTY -041	QTY -1	P/N	DESCRIPTION
1	X		D3755-041	CUSHION
2	1	X	D3755-1	COVER
3	1		D3753-1	SEAT FOAM
4		2	D3800-1-200-060	LOOP STRIP
5		1	D3800-1-100-300	LOOP STRIP (CUT/FIT AS REQ'D)
6		1	D3800-3-100-300	HOOK STRIP (CUT/FIT AS REQ'D)
7		A/R	SY-111	SURREY SILVER SUNSET UPHOLSTERY, MORBERN INC. P/N SY-111
8		A/R	THREAD	BONDED POLYESTER, 14.2 lb BREAK STRENGTH, GREY COLOR

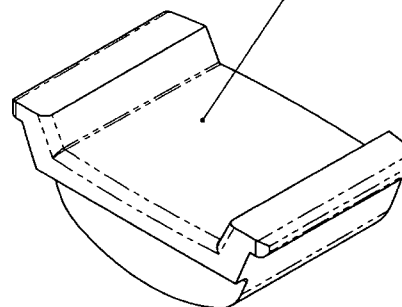
W/050662

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING

UNDER REVIEW

07.02.09
PAR 09-012
OK 08.04.06

COVER SHOULD BE TIGHT TO
FOAM IN CONCAVE AREA SHOWN



D3755-041 CUSHION

50662

RELEASED
08/11/05

NOTES:

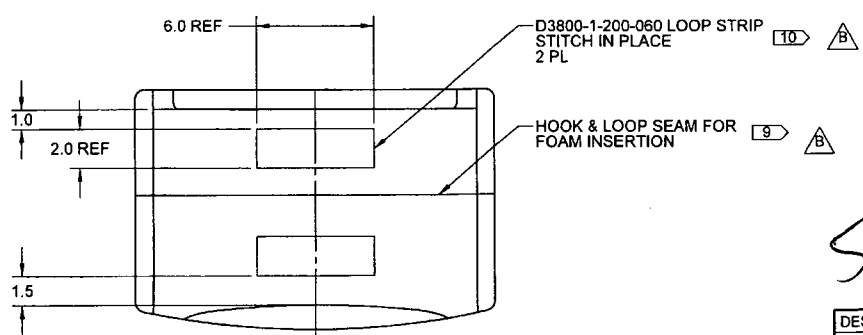
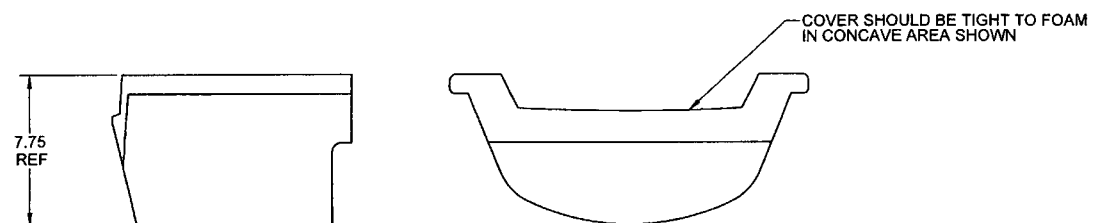
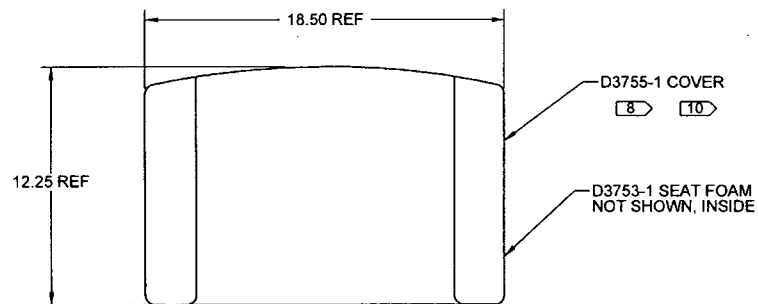
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3755-041" USING LABEL
- 7) WEIGHT: 3.0 lbs
- 8) SEW D3755-1 COVER TO FIT D3753-1 FOAM
- 9) STITCH D3800-1-100-300 LOOP AND D3800-3-100-300 HOOK STRIPS ALONG EDGE OF SEAM TO CLOSE COVER, INSTALL THE HOOK STRIP ON THE TOP OVERLAPPING FLAP, INSTALL THE LOOP STRIP ON FABRIC NEXT TO FOAM
- 10) STITCHING: 4-6 STITCHES PER INCH, USE MIN 1/2" BACKSTITCH, NO LOOSE THREADS
- 11) CUSHION SHAPE / FORM / PATTERN TO CONFORM WITH TEMPLATE DT9419

B	COVER NOW CLOSED WITH SINGLE SEAM (ZN A8-1, B3-2), D3800-1-100-300 WAS D3800-1-100-800 (D8-1), D3800-3-100-300 WAS D3800-3-100-500 (D8-1), ORIENTATION OF D3800-1-200-060 CHANGED (B3-2), ADD ITEM NUMBERS TO PART LIST (D8-1)	CP	08.10.21
A	NEW ISSUE	CP	08.09.09
REV.	DESCRIPTION	BY	DATE
DESIGN	07		
DRAWN	07		
CHECKED	04		
MFG. APPR.	03		
APPROVED	04		
DE APPR.	04		
DATE	08.10.21		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3755 TITLE CUSHION SCALE NTS REV. B SHEET 1 OF 2 COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

UNDER REVIEW

08/10/05

OK UP 09.0406



D3755-041 SEAT CUSHION

50662

RELEASED

08/11/05

DESIGN	90	DART AEROSPACE LTD	
DRAWN	90	HAWKESBURY, ONTARIO, CANADA	
CHECKED	04	DRAWING NO. D3755	REV. B
MFG. APPR.	02	SHEET 2 OF 2	
APPROVED	02	TITLE CUSHION	SCALE
DE APPR.	02	NTS	
DATE	08.10.21	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

JUL-22-2009 08:02 FROM-CHESTNUT RIDGE FOAM
Chestnut Ridge Foam, Inc.
443 Warehouse Drive
P.O. Box 781
Latrobe PA 15650

T-129 P.001/001 F-495
Phone: 724-537-9000
Fax: 724-537-9003 (9004)



Sales Order: 35807

SALES ORDER ACKNOWLEDGEMENT

Page: 1

Sold To:

Fax: Linda Laccile
Dart Aerospace Ltd.
1270 Aberdeen Street
Tel: 613-632-3336
Hawkesbury ONTARIO, CANADA K6A 1K7

Ship To:

Fed Exp #1517-9324-0
Dart Aerospace Ltd.
1270 Aberdeen Street
Tel: 613-632-3336
Hawkesbury ONTARIO, CANADA K6A 1K7

Ship to Fax 613-632-4443

Order Date: 7/21/2009 PO Number: PO10106
Need By: 8/18/2009 Sales Rep: Lee Danovitz
Terms: Net 30 Days Ship Via: Fed X Economy

FOB: Origin
Freight Terms: Collect

Ship ASAP! Customer requests a 7-23-09 ship date.

Certificate of Conformity that all components comply with 14CFR 25.853(a) Vertical Burn with shipment

Line	Order Qty	Part Number/Description	Revision	Unit Price	Ext. Price
1	6.00EA	D3753-1		64.82000 /E	388.92

D3753-1 AIRFLEX Bottom Cushion (P1)

Our Part: CRF#503330-99

Release	Date	Quantity
1	8/18/2009	6.00

Line	Order Qty	Part Number/Description	Revision	Unit Price	Ext. Price
2	6.00EA	D3754-1		73.50000 /E	441.00

D3754-1 AIRFLEX Back Cushion (P1)

Our Part: CRF#603150-99

Release	Date	Quantity
1	8/18/2009	6.00

Line Total: 829.92
Miscellaneous Total: 0.00
Total: 829.92

We hereby certify that these goods were produced in compliance with all applicable requirements of section 6,7, and 12 of the Fair Labor Standards Act as amended and of regulations and orders of the United States Department of Labor issued under section 14 thereof.

Kim Rodarte

Accepted by

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Chestnut Ridge
Foam, Inc.

Fax

To: DART-CHANTAL

From: LAURA McWHERTER

Fax: 613-632-1053

Pages:

Phone:

Date: AUGUST 18, 2009

Re:

CC:

☐ Urgent ☒ For Review ☐ Please Comment ☐ Please Reply ☐ Please Recycle



Chestnut Ridge
Foam, Inc.

CERTIFICATE OF CONFORMANCE

SOLD TO:
DART AEROSPACE
1270 ABERDEEN STREET
HAWKESBURY
ONTARIO, CANADA K6A1K7

PURCHASE ORDER: PO10106
SALES ORDER: 35807
DATE SHIPPED: 08/10/09

I certify that the individual components comprising the part shipped against the above-referenced purchase order meets the following requirements:

14 CFR 25.853(a), APPENDIX F, PART 1(a)(1)(ii), AMENDMENT 25-116

Quantity	Customer Part Number	Part Number	Material	Batch Number
6	D3753-1	503330-99	AIRFLEX40-50 AIRFLEX55-65	AF9015 AF9032
6	D3754-1	603150-99	AIRFLEX30-40	AF9028

MADE IN THE U.S.A

Mark A. Brown
Technical Director

S
09/06/18

CHESTNUT RIDGE FOAM INC.
VERTICAL BURN TEST # 11517
12-SECOND VERTICAL BUNSEN BURNER TEST
FOR CABIN AND CARGO COMPARTMENT MATERIALS
SHOWING COMPLIANCE TO THE REQUIREMENTS OF 14 CFR 25.853

PRODUCT : AIRFLEX
BATCH / LOT NO : AF9015
CUSTOMER : PRODUCTION
P.O. NO :
OTHER IDENTIFICATION : AFX 40-50

TEST BEING RUN : VERTICAL BUNSEN BURNER TEST: 12 SECOND IGNITION TIME

MATERIAL COMPOSITION : AIRFLEX

MATERIAL PATTERN : NA

MATERIAL COLOR : YELLOW

FLAME TEMPERATURE : 1560°F

CONDITIONING STARTED : DATE : 4-2-09
TIME : 8:30 AM

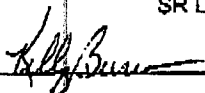
TEST STARTED : DATE : 4-3-09
TIME : 9:20 AM

RESULTS :	FLAME TIME (SECONDS)	DRIPPINGS (SECONDS)	BURN LENGTH (INCHES)
#1.	0.4	0.0	6.2
#2.	0.9	0.0	6.7
#3.	1.0	0.0	6.3
AVG.	0.8	0.0	6.4
PASS : X	FAIL :		

COMMENTS :

THIS MATERIAL MEETS THE REQUIREMENTS OF THE 14 CFR, PART 25, SECTION 25.853, PARAGRAPH (a) AND APPENDIX F, PART 1, (a), (1), (ii).

TESTED BY : KELLY BURES
SR LAB TECHNICIAN



CHESTNUT RIDGE FOAM INC.
VERTICAL BURN TEST # 11682
12-SECOND VERTICAL BUNSEN BURNER TEST
FOR CABIN AND CARGO COMPARTMENT MATERIALS
SHOWING COMPLIANCE TO THE REQUIREMENTS OF 14 CFR 25.853

PRODUCT : AIRFLEX
BATCH / LOT NO : AF9032
CUSTOMER : PRODUCTION
P.O. NO :
OTHER IDENTIFICATION : AFX 55-65

TEST BEING RUN : VERTICAL BUNSEN BURNER TEST: 12 SECOND IGNITION TIME

MATERIAL COMPOSITION : AIRFLEX

MATERIAL PATTERN : NA

MATERIAL COLOR : ORANGE

FLAME TEMPERATURE : 1554°F

CONDITIONING STARTED : DATE : 7-27-09
TIME : 10:30 AM

TEST STARTED : DATE : 7-28-09
TIME : 11:20 AM

S
07/28/09

RESULTS :

	FLAME TIME (SECONDS)	DRIPPINGS (SECONDS)	BURN LENGTH (INCHES)
#1.	0.0	0.0	7.1
#2.	0.0	0.0	6.8
#3.	0.0	0.0	6.7
AVG.	0.0	0.0	6.9

PASS : X FAIL :

COMMENTS :

THIS MATERIAL MEETS THE REQUIREMENTS OF THE 14 CFR, PART 25, SECTION 25.853,
PARAGRAPH (a) AND APPENDIX F, PART 1. (a), (1), (ii).

TESTED BY : KELLY BURES
SR. LAB TECHNICIAN

Kelly Bures

L Lacelle

From: Bill Beckett [bbeckett@dartaero.com]
Sent: November 3, 2009 1:14 PM
To: 'L Lacelle'
Subject: RE: For Chestnut Ridge Approval

Scrap.
Bill

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: September 16, 2009 12:42 PM
To: 'Bill Beckett'
Subject: FW: For Chestnut Ridge Approval

Bill,
Are these still usable? Or are they scrap?

LL

From: Chantal Lavoie [mailto:clavoie@dartaero.com]
Sent: September 16, 2009 12:33 PM
To: 'L Lacelle'
Subject: FW: For Chestnut Ridge Approval

Linda,
There was a new rev. for the cushion D3755 & D3756 but not under review, I checked with Chestnut RidgeFoam to have them modified , but they cannot be modified. What should we do with them .
Chantal

From: Idanovitz@chestnutridgefoam.com [mailto:Idanovitz@chestnutridgefoam.com]
Sent: September 10, 2009 2:09 PM
To: 'Chantal Lavoie'
Cc: nwissinger@chestnutridgefoam.com
Subject: RE: For Chestnut Ridge Approval

Chantal,

Thank you for forwarding the drawings. We have reviewed and found two things, the cushions that you have in stock can not be modified and we need more information in order to produce First article samples for you. Would it be possible for you to forward a STP or DWG file? Thanks in advance for your help.

Best regards,

Lee Danovitz
Sales Manager Aircraft Applications
Chestnut Ridge Foam, Inc.
Phone: (724) 537-9000
Fax: (724) 537-9003
Idanovitz@chestnutridgefoam.com

11/13/09

From: Chantal Lavoie [mailto:clavoie@dartaero.com]
Sent: Thursday, September 10, 2009 12:37 PM
To: Idanovitz@chestnutridgefoam.com
Subject: FW: For Chestnut Ridge Approval

Lee, please see the attach: for the revised cushion.
Thanks
Chantal

From: Alan Stocker [mailto:astocker@dartaero.com]
Sent: July 31, 2009 2:41 PM
To: 'Chantal Lavoie'
Cc: 'Mike Petsche'
Subject: For Chestnut Ridge Approval

Hi Chantal,

Can you send these to Chestnut Ridge and get a thumbs up or thumbs down please.

Thanks

Alan Stocker
Mechanical Designer
Dart Aerospace
1270 Aberdeen Street
Hawkesbury, Ontario
CANADA K6A 1K7
(613) 632 5200 x 241
astocker@dartaero.com